Work Order ID 93746 Page 1 November-27-12 11:02:27 AM Setup Start Item ID: D3912-3 Accept *N900040100* **Revision ID:** Eyebolt Block Item Name: **Start Qty: 24.00 Start Date:** 11/22/12 **Cust Item ID:** Required Date: 12/07/12 Req'd Qty: 24.00 **Customer:** Reference: Run Process Plan: HLJ Date: 12-11-27 Tooling: Approvals: Stop **SPC (Y/N):** Date: Date: Reject Reject Set Up/ Tool ID Tool # Plan Accept Insp. Sequence ID/ Operation **Qty** Number Stamp **Work Center ID** Description Code Oty **Run Hours** Revision Nbr Draw Nbr D3912 В 0.00 100 Cut blanks as per folio *100* 24 % Bandsaw 0.00 Memo FK- 12/12/23 Jeaspa Bandsaw CUT BLANK 2.50" LONG 110 0.00*110* 0.00 HAAS I Memo MACHINE AS PER FOLIO FA870 AND DWG HAAS CNC vertical machine #1 F.K. 12/12/23 FOLIO REV: A DWG REV: 8 DEBURR

				DQA:	Date:	
ICR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

					<u> </u>					QA Closed.	Date	<u>•</u>
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		noforming	Finishing		e/Packaging	Other
NCR N	lo				Work Order Update	1		Large Fab	Composite		Supplier	
Root				Descrip	otion of work order update	In	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	0	r Non-conformance	Chi	ef Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling										,		
Operator												
Material												
Setup												
Other												
Process			1									
Supplier												•
Training									•			
Unapproved					•							
					F	AULT	CATE	GORY		,		
Landi	ng Gear				General							_
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to O/S	· . \square	BOM/Route	\prod_{i}	Hardwa	re		Over/Under	tolerance	Temperature/Cure
ĺ	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorred	ct -	Weld
	Crushed/	Crimped.			Burrs		nstruct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
ſ	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	
İ	Inspectio	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	П	Offset					•
	Torque W	/aves in E	xtrusion		Drawing	\Box	Out of C	Calibration				
	Turning S				Finish		Out of S	equence				
1	Wave/Tw	•	10		Folio	-		Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord November-27-12			·	*0	37	'46*						Page 2
Revision ID:	D3912-3 Eyebolt Block			Accept		*N900	040	100)* s	Setup Star Sto	1 1	S1* S2*
	11/22/12	Start Qty: 24.00 Req'd Qty: 24.00	*74* *74*			Cust Item II Customer:) :				I	. 7/
Approvals:		n:		Tooling: SPC (Y/N		Da	te:		F.	Run Star Sto	I./J	R1* R2*
Sequence ID/ Work Center II 120)	Operation Description QC2- Inspect parts off ma	achine FAI/FAIB	Set Up/ Run Ho		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control		Memo		0.00	FK	12/12/23			24	<u>Ø</u>		
*130		QC8- Inspect parts - seco	and check		07	12/12/2	4		24			
QC Quality Control		Memo		0.00								
160		Identify as per dwg & Sto	ock Location	0.00					ſ		Δ	, /

0.00

Memo

160

Packaging

Packaging

NCR: Yes / No						WORK ORDER NON-C	CON	ORN	MANCE / UP	DATE			
						r					QA Closed:	Date	2:
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part I						Rework Scrap	}		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR 1						Use-as-is Work Order Update]	Therm	noforming Large Fab	Finishing Composite		re/Packaging Supplier	Other
Root		ŀ			Descri	ption of work order update	Ini	tial	Ac	tion	Sign &		
Cause	Di	ate	Step	Qty	(or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator		1											
Material													
Setup		1											
Other		1				-							
Process													
Supplier		l											
Training													
Unapproved													
						F	AULT	CATE	GORY				
Landi	ng Gear					General	_				_	-	_
	Bend	ding			_	Bend	∐G	irain			Ovalized		Pressure/Forced
	Cent	re No	t Concer	ntric to (O/S	BOM/Route	Шн	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Crac	ks				Broken/Damaged	Ir	rspecti	on Incomplete		Part Incorre	ct _	Weld
	Crus	hed/C	rimped.			Burrs	L Ir	struct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuff	5				Contamination	\square	/lainte	nance		Part Moved		
	Heat	Treat	İ			Countersink	Шм	1islabe	led		Positioned V	Vrong	_
	Insp	ection	Strip in	Tube		Cut Too Short	Шм	1isread	I		Power Loss/	Surge	Other
	Ripp	les in	Bend			Drill Holes		ffset		-			
	Toro	ue Wa	aves in F	ytrusio	, [Drawing		ut of C	alibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord November-27-1				,	Page 3							
Item ID: Revision ID: Item Name:	D3912-3 Eyebolt Bloc	.k	-	Accept	*N900	040	100)* :	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	11/22/12 e: 12/07/12	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item I. Customer:	D:						
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):		ite:		J	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center	ID	Operation Description	Work Order Polesco	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp

0.00

Memo

170

Quality Control

13/1/10 H

										DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-C	O	NFORI	MANCE / UPI		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
Part No.					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	ı	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling]											
Operator								,				
Material												
Setup				٠.,								
Other					•							
Process												

Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

FAULT CATEGORY

Grain

Hardware

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Lost/Missing

Over/Under tolerance

Pressure/Forced

Weld

Temperature/Cure

Wrong Stock Pulled

General

Bend

Burrs

BOM/Route

Broken/Damaged

Supplier Training Unapproved

Landing Gear

Bending

Cracks

Crushed/Crimped.

Centre Not Concentric to O/S

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

November-27-12 11:02:26 AM

Page 1

Work Order ID:

93746

Parent Item:

D3912-3

Parent Item Name:

Eyebolt Block

Start Date: 11/22/12

Required Date: 12/07/12

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000 303 BAR 1" X 1"		Purchased	No		_,	100	f	1.8149	0.208	5.2547376			******************************
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT050		1.8148904							
				1222	17	1.8148904							
				124	1081				5.	255 т	-, ,		

											ຜ້	DQA:	Date	: :
NCR:	⁄es	/ No					WORK ORDER NON-C	OI	NFORI	MANCE / UP	DATE			
												QA Closed:	Date	2:
Work Ord	er:		•				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part f	•	****					Rework Scrap		Skid-tube Crosstube Machining Small Fab		Pro	Water Jet d. Eng. Coor.	Engineering Quality	
NCR I	No.						Use-as-is The Work Order Update			Thermoforming Finishing Large Fab Composite		Rec/Store/Packaging Supplie		Other
Root			-		Desc	crip	tion of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or	Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data														
quip/Tooling													·	
perator					•									
laterial														
etup														
ther														
rocess														
upplier												ĺ		
raining														
napproved														
						*4	F	AUL	T CATE	GORY				
Landi	ng (iear					General							
		Bending			ſ	\Box	Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to (o/s	1	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	<u> </u>	Weld
	Cracks Crushed/Crimped			_	Burrs		1 '	ions Incomplete/	Unclear	Part Lost/M	<u> </u>	Wrong Stock Pulled		
	Cuffs			-	Contamination		Mainte	•		Part Moved	·			
	\vdash			_	Countersink		Mislabe		<u> </u>	Positioned V	Vrong			
į	Inspection Strip in Tube Cut Too Short						Misread			Power Loss/		Other		
	Ripples in Bend Drill Holes							Offset		_			T. T.	
	Torque Waves in Extrusion Drawing						Out of Calibration							
	Turning Sequence					_	Finish	Out of Sequence						

Outside Dimensions

Wave/Twist in Tube

Folio

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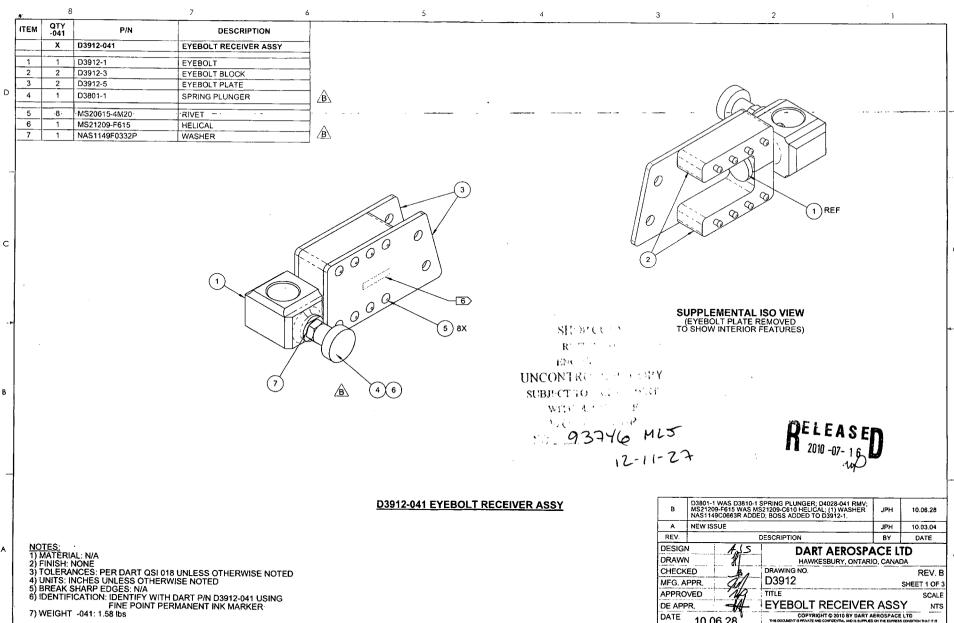
DART AEROSPACE LTD	Work Order:	93746
Description: Eyebolt Block	Part Number:	D3912-3
Inspection Dwg: D3912 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Assert	Dainet	Method of	0
Dimension	rolerance	Dimension	Accept	Reject	Inspection	Comments
2.30	+/-0.030	2,305	7		FK-04	Vern
Ø0.129	+0.005/-0.001	.1582	7		"	Vern
0.50 Ref	+/-0.030	.501	7		11	′,
R0.13	+/-0.030	.130	7		R-G	
0.500	+/-0.010	.493	7		FK-O4	Vern.
R0.125	+/-0.010	.135	7		R-G	
0.63	+/-0.030	-629	V		FK-04	Venn.
0.750	+0.000/-0.020	.740	1		11	1
0.38	+/-0.030	.38	V		n .	M
1.500	+/-0.010	1,500	V		il	1
0.500 Pitch	+/-0.010	,500	7		þ	`
0.800	+0.000/-0.010	.799	7		И	St.
0.400	+/-0.010	.398	7		h	<u>, </u>
0.516	+0.015/-0.000	, 520	~		10	Ъ
1.00	+/-0.030	, 994	7		Ai .	Ŋ
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111111111111111111111111111111111111111						
		-				
- Variabili.						
			i			

Measured by:	F.K.	Audited by:	04	Preliminary Approval:	
Date:	12/12/23	Date:	12/12/211	Date:	

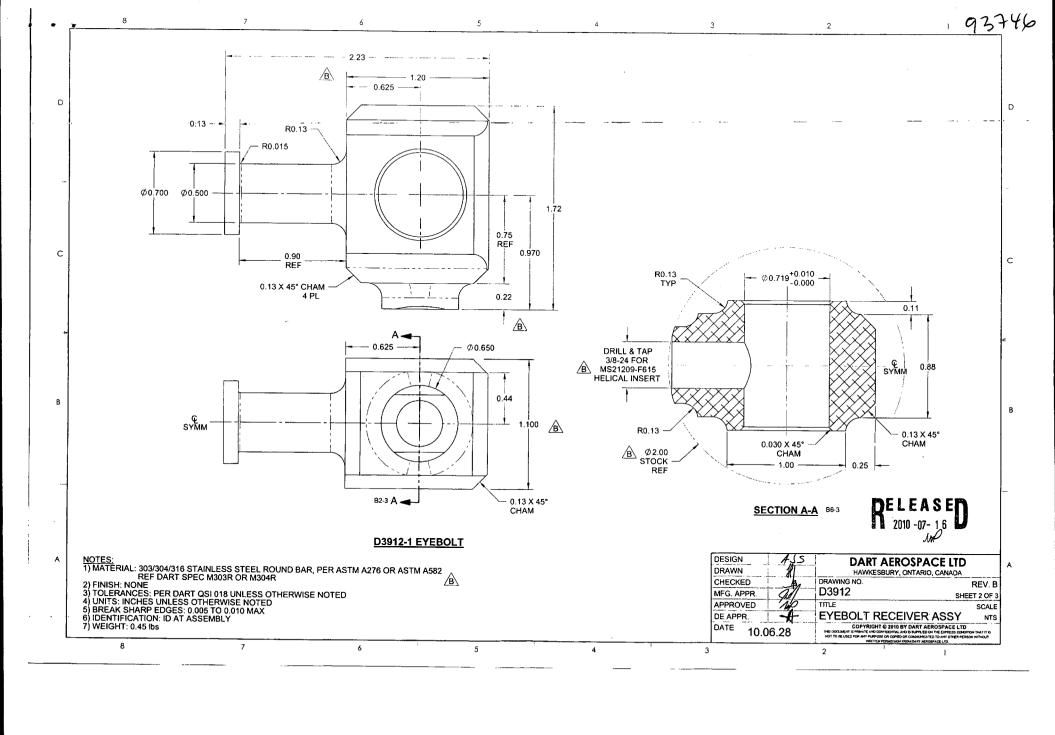
Rev	Date	Change	Revised by	Approved
Α	10.06.07	New Issue	KJ 🔥	
В	12.05.15	Dwg Rev updated	KJ OH	(Timel
			17)	



EYEBOLT RECEIVER ASSY DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD DATE 10.06.28

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93746

--0.800+0.000 - 2.30 Ø0.129 THRU 1.500 4 PL --- 0.400 ---0.500 PITCH 0.50 REF 1.00 0.750 +0.000 -0.020 0.500 R0.13 R0.125 0.516+0.015 0.63

D3912-3 EYEBOLT BLOCK

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

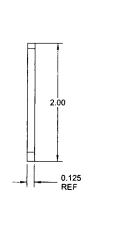
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С

- 2) FINISH: NONE
 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: ID AT ASSEMBLY
 7) WEIGHT -3: 0.30 lbs
 -5: 0.24 lbs

1.500 0.500 PITCH 10.375 R0.13 TYP - 0.38 0.25 1.000 1.500 +0.020 REF Ø0.129 Ø0.257 8 PL 2 PL 3.69 REF



D3912-5 EYEBOLT PLATE

DESIGN #55 DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	A,	DRAWING NO.	REV. B
MFG. APPR.	20/	D3912 SHE	ET 3 OF 3
APPROVED /	UG	TITLE	SCALE
DE APPR.	M	EYEBOLT RECEIVER ASSY	NTS
DATE 10.06.28		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS COCUMENT IS REPRIME AND CONFERENCE, AND IS SUPPLIED ON THE EXPRESS CONFIDENT HAT IT IS NOT TO BE USED FOR ANY HUMPOSE OR COPAGE ON COMMANDATION TO ANY OTHER POPEROW HYTHOUT	